

Date: Thursday, 18/09/2008 11:12:36 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WELDMENT TOP PANEL  
 Job Number : 42095  
 Estimate Number : 13029  
 P.O. Number :  
 This Issue : 18/09/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D36503  
 First Issue : 11 Type : SMALL / MED FAB Drawing Number : D3650 REV.B  
 Previous Run : 39933 Drawing Revision : B  
 Written By :  
 Checked & Approved By : JULIE LECOCQ  
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC  
 Est Rev:B ECN 1113P 08-01-22 DD  
 Est Rev:C ecn1162 08-04-02 DD verified by: EC

## Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET

Comment: Qty.: 1.2023 sf(s)/Unit Total: 6.0113 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)  
 Batch: 108-115 1B 8-9-26

2.0 WATER JET 109398 FLOW WATER JET

Comment: FLOW WATER JET  
 1-Cut as per Dwg D3650  
 Dwg Rev: B 1B 8-9-26  
 Prog Rev: B

2-Deburr if necessary 1B 8-9-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE

Comment: NC BRAKE  
 Form as per Dwg D3650



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 42095

Part Number: D36503

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/10/05 (x3)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8.0

D365011

Filler Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

FILLER PLATE

batch

*29949*

*B40694 → 23\**

*Plc 08-11-05*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-trim to fit (D3650-11)

2-Weld assembly as per dwg D3650 QSI004

3-grind weld smooth if necessary

*Plc 08-11-05*

*(x3)*

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*08/11/05 (3)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/10/06 (x3)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location:

*Sylvie*

*8/11/06*

*(3x)*

*SD*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/11/06*

Job Completion



*Inf 08-11-06*





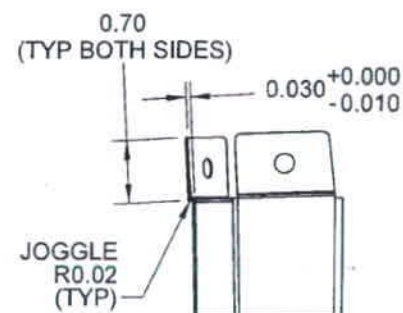




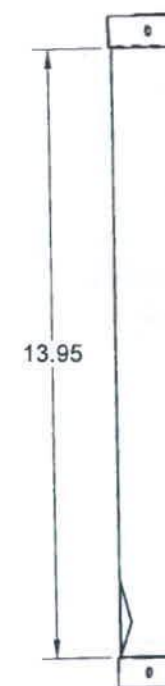
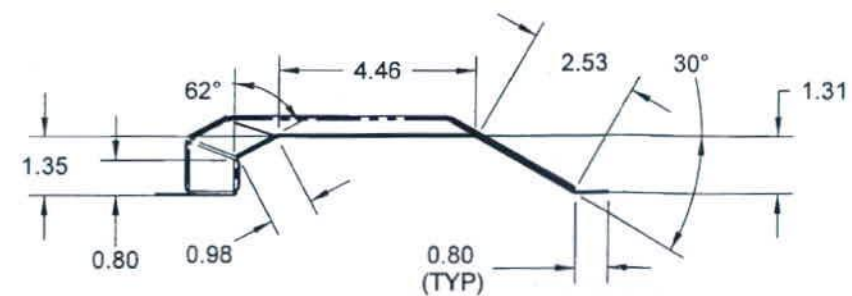
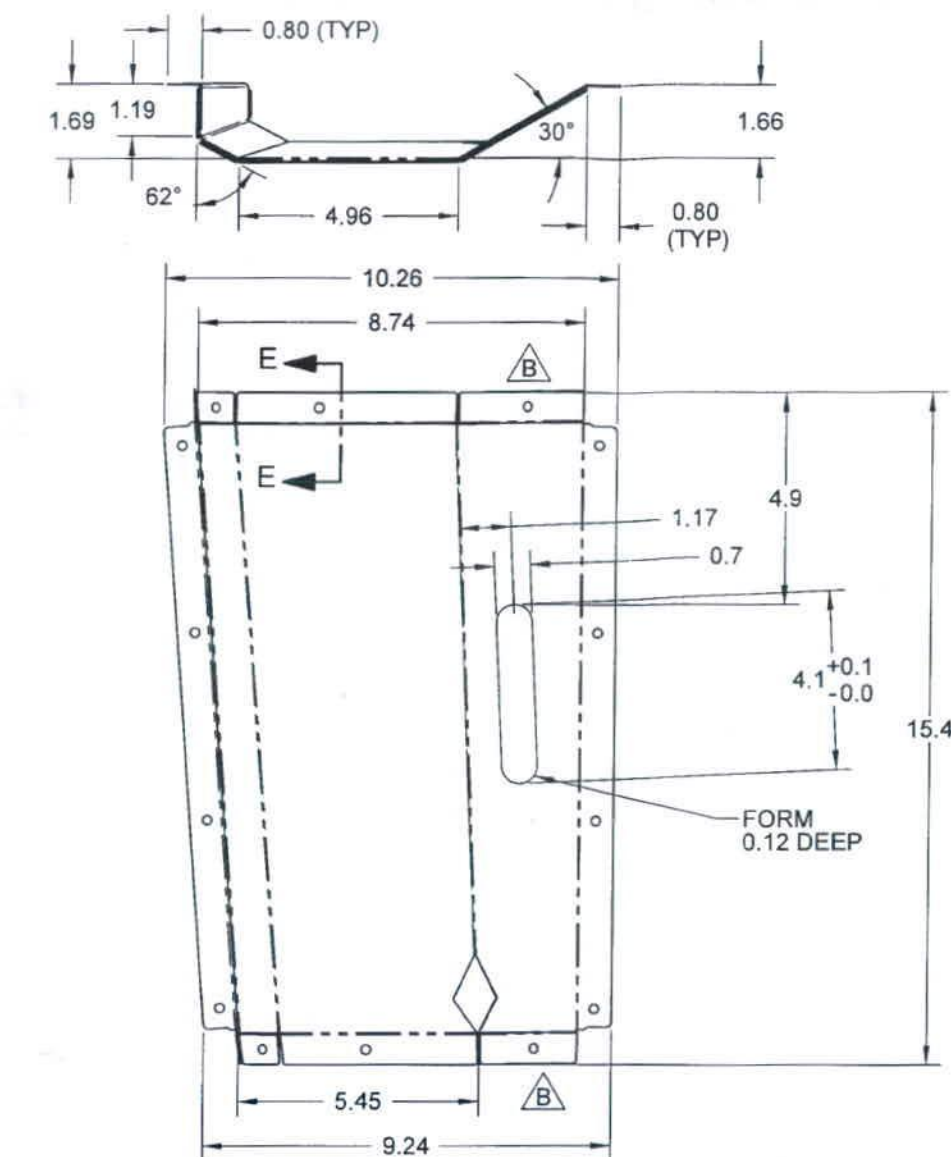








**SECTION E-E**



- NOTES:**  
 1) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE

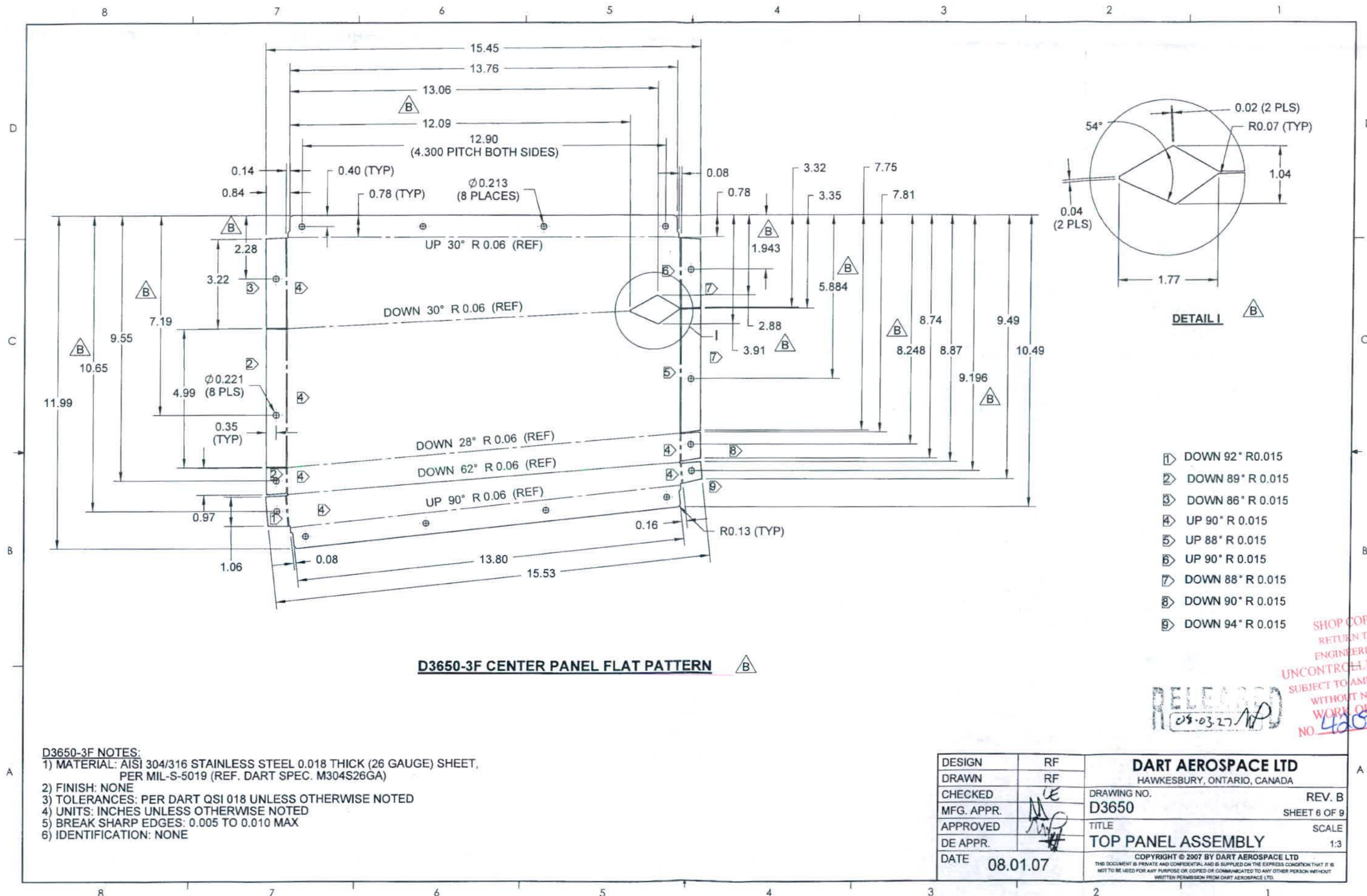
**D3650-3B CENTER PANEL BENT PART**  
 (MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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